

Work Order ID 111675

Friday, January 17, 2014 11:14:07 AM

111675

Page 1

Item ID: D119-646-143

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float


Start Date: 1/17/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:  Date: 1/17/14 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3905-043	C								
IIN-D119-646	B								

100

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D119-646-143
CHG 003

110

0.00

110

Skidtubes

Memo

0.00

Skidtubes

1- Inspect Mat'l D2500-1-190 for damage

2- Ensure squareness of ends

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Item ID: D119-646-143

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Stop *NS2*

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Required Date: 1/24/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 Chemical Conversion Coat per QSI005 4.1

0.00

120

0.00

HandFinish

Memo

Hand Finishing

130 QC7-Inspect Chemical Conversion Coat

0.00

130

0.00

QC

Memo

Quality Control

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

150

Skidtubes

Memo

0.00

1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill first side only.

2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes.

3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477

4- Scribe batch # inside aft end of tube

155

0.00

155

CNC Bend 1

Memo

0.00

1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end.

2- Ensure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

CNC Delta 100 Bender

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Memo

0.00

Quality Control

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

0.00

Skidtubes

Memo

Skidtubes

1- Veriffy dimation of bend as per dwg D3905

2- Buff out marks left from bending.

3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, spot face most fwd, top facing wearplate holes to 0.5626" to accomodate insert (1 per side) open to finished size

4- Drill Aft wearplate and wearpad holes using DT9545 as per dwg D3905 detail H open to finished size

5- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E)
DO NOT OPEN FWD SADDLE HOLES

6- Deburr, blow out chips from inside of tube

7-Bond web in place as per Dwg D3905 & QSI 015.

A/RSikaflex-291

Sikaflex expire date: _____

Start: _____

Time: _____

Finish: _____

Time: _____

***** (Adhere for 12 hours) *****

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

0.00

200

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend Fwd end of tube using bender 1 and bend prog. D3905 Fwd.Use
bending aid DT9544 ensure proper positioning

2- Cut Fwd end of tube as per dwg.

VERIFY MEASUREMENT BEFORE CUTTING

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

0.00

210

0.00

Skidtubes

Memo

Skidtubes

1- Buff out marks left from bending

2- Drill Fwd cap holes using DT8215.

3- Open Fwd saddle holes to finished size as per dwg

4- Drill Fwd x-bolt hole using DT9816 and open to finished size as per dwg.

5- Drill 1.87" and 3.74 holes using DT9494 locate from FWD cap hole. (verify measurement) as per dwg DEO D3905-B-1.

6- Drill towring hole and open to finished size using DT9494

7- Drill wearplate holes using DT9613, open to finished size as per dwg D3905-043

8- Open FWD & AFT cap holes as dwg.

9- Deburr, blow out chips from inside of tube.

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							
220									
QC	Memo	0.00							
Quality Control									
224		0.00							
224									
Skidtubes	Memo	0.00							
Skidtubes	1- Countersink x-bolt holes as per dwg								
	2- Remove alodine prepare for welding								
	3- Insert x-bolt spacers								
	4- Weld x-bolt spacer as per dwg A/R Alum rod Batch: _____								
	5- Grind welds flush as per dwg								
	6- Counter bore x-bolt holes as per dwg								
	7- Deburr								

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
225	QC5- Inspect part completeness to step on W/O	0.00							
225									
QC	Memo	0.00							
Quality Control									
226	QC10- Inspect visual per QSI004- ground welds	0.00							
226									
QC	Memo	0.00							
Quality Control									
227	Pressure Wash per QSI005 4.3	0.00							
227									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

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Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating									
245	QC3- Inspect Part Finish	0.00							
245									
QC	Memo	0.00							
Quality Control									
250		0.00							
250									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3905.								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/RSikaflex-240/-291 _____ Sikaflex expire date: _____ 2- install plugs assembly with o-ring lube as per dwg. A/R o-ring lube 55 Batch: _____ 3 -Inspect for foreign objects as per QSI 024 4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-240/-291 _____ Sikaflex expire date: _____ 5- Wing Walk as per dwg QSI005 4.4 Batch: _____								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

286

QC3- Inspect Part Finish

0.00

286

QC

Memo

0.00

Quality Control

290

Identify as per dwg & Stock Location: _____

0.00

290

Packaging

Memo

0.00

Packaging

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 111675

111675

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20
per chg003 ECN13-534 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190		Manufactured	No			110	Each	81.0000	1	1			
D2500-1-190									**				
Ext'n - 'I' Beam Tube 4"													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				HALL				81					
				105279				80					
				80061				1					
D2579		Manufactured	No				Each	19.0000		2			
D2579									**				
Crossbolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				19					
				105932				19					
D2855-3		Manufactured	No			270	Each	2.0000	2	2			
D2855-3									**				
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				2					
				102169				2					
D3492-5		Manufactured	No			270	Each	144.0000	16	16			
D3492-5									**				
Plug													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				144					
				104854				65					
				105612				79					

Picklist Print

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Page 2

Work Order ID: 111675

111675

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

270

Each

192.0000

16

16

NAS1611-005

O-RING

Location

Loc Qty

Loc Code

FP001

192

m125807

4

m126974

188

D3672-1

Manufactured

No

270

Each

936.0000

2

2

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

926

103845

136

93886

522

99099

268

D3681-1

Manufactured

No

190

Each

212.0000

8

8

D3681-1

Spacer

Location

Loc Qty

Loc Code

LG001

212

102202

11

108647

65

109109

136

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Work Order ID: 111675

111675

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D3846-1	Manufactured	No	270	Each	19.0000	1	1
---------	--------------	----	-----	------	---------	---	---

D3846-1******

Gasket

LocationLoc QtyLoc Code

FP001

19

51827

4

53735

15

D3846-11	Manufactured	No	270	Each	47.0000	1	1
----------	--------------	----	-----	------	---------	---	---

D3846-11******

Gasket

LocationLoc QtyLoc Code

FP002

47

93954

47

D3847-1	Manufactured	No	270	Each	24.0000	8	8
---------	--------------	----	-----	------	---------	---	---

D3847-1******

Wearpad

LocationLoc QtyLoc Code

FP001

24

88420

24

D3847-11	Manufactured	No	270	Each	5.0000	1	1
----------	--------------	----	-----	------	--------	---	---

D3847-11******

Wearpad

LocationLoc QtyLoc Code

FP001

5

88556

5

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Page 4

Work Order ID: 111675

111675

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D3847-043

Manufactured No

270

Each

5.0000

1

1

D3847-043

Fwd Wearplate Assy, Std/ Float Gear

Location

Loc Qty

Loc Code

FP002

5

51820

1

52533

2

88540

2

D3847-045

Manufactured No

270

Each

7.0000

1

1

D3847-045

Center Wearplate Assy, Std/Float

Location

Loc Qty

Loc Code

FP002

7

87210

4

88242

3

D3847-049

Manufactured No

270

Each

6.0000

1

1

D3847-049

Aft Wearplate Assembly, Float Gear

Location

Loc Qty

Loc Code

FP002

2

88267

2

ST500

4

93904

4

D3885-3

Manufactured No

170

Each

9.0000

1

1

D3885-3

Standard Web

Location

Loc Qty

Loc Code

LG002

9

52425

1

99134

8

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Work Order ID: 111675

111675

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D3903-1 Manufactured No 190 Each 69.0000 12 12

D3903-1

Spacer

Location Loc Qty Loc Code

LG001 69 _____
109112 69 _____

D3672-3 Manufactured No 270 Each 866.0000 12 12

D3672-3

Phenolic Washer

Location Loc Qty Loc Code

FG 111 _____
84432 11 _____
89273 100 _____
FP001 87 _____
107316 87 _____
ST060 500 _____
110251 500 _____
ST061 168 _____
93925 168 _____

D3683-3 Purchased No 250 Each 271.0000 12 12

D3683-3

Insert

Location Loc Qty Loc Code

ST061 271 _____
47805 271 _____

ALS4-1032-130 Purchased No 250 Each 1,817.000 42 42

ALS4-1032-130

Rivnut

Location Loc Qty Loc Code

st510 1817 _____
M126109 1817 _____

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Page 6

Work Order ID: 111675

111675

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 270 Each 111.0000 44 44

AN3C5A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
122800	5	
ST350	106	
m127290	106	

NAS1149C0332R Purchased No Each 11,236.00 44

NAS1149C0332R

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	1229	
125654	1229	
st510	10007	
m126319	2107	
m127306	2500	
m127410	3000	
m127831	2400	

NAS1149C0463R Purchased No Each 500.0000 12

NAS1149C0463R

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	21	
119097	21	
ST292	479	
123248	1	
123355	178	
m127306	300	

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Work Order ID: 111675

111675

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039C4-08

Purchased

No

270

Each

144.0000

12

12

MS27039C4-08

SCREW

Location

Loc Qty

Loc Code

ST308

144

m126319

144

MS24694-C52

Purchased

No

Each

150.0000

2

MS24694-C52

SCREW

Location

Loc Qty

Loc Code

ST301

150

124308

50

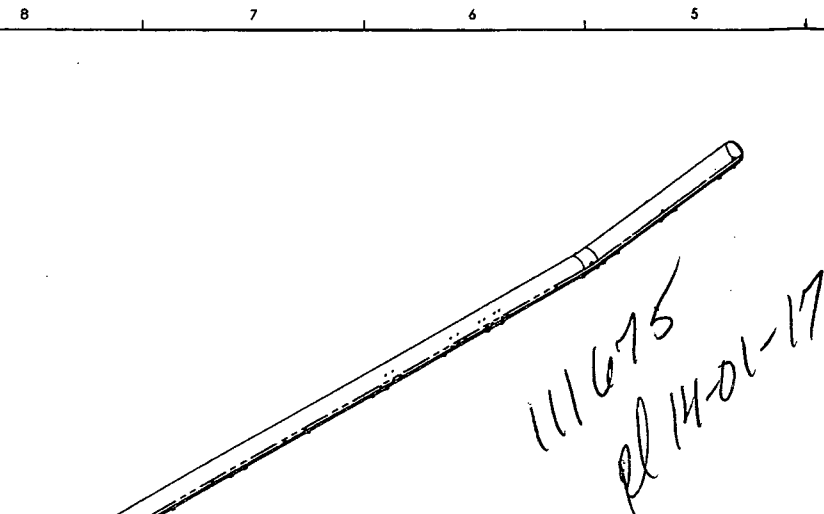
m127059

100

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D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs
 D3905-043 = 47.0 lbs
 D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
 THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
10	2	2	2	D2579	CROSS BOLT SPACER
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	2	2	2	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	44	44	12	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	44	44	8	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW
49	2	2	2	MS24684-C52	SCREW

RELEASED
 2013-03-19

C	(SHT 1 P/L, ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 45, QTY 44 WAS 48, ADD ITEM 49, MS24684-C52 WAS AN3C5A, D3672-1 AND NAS1149C0332R, (ZN C7-7) Ø0.201 CSK Ø0.395 X 100" WAS Ø0.204 THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C8-7, D8-7)	DB	13.02.21
B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2579 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8), REVISED NOTE 4 (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DS	D3905	SHEET 1 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	#	A119 FLOAT SKIDTUBE ASSY NTS	
DATE	13.02.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

AN3C5A BOLT
D3872-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3846-11
GASKET

D3847-11
WEARPAD

MS27039C4-08 SCREW
NAS1149C0463R WASHER
D3872-3 WASHER
12 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø 0.197
8 PL PER SIDE
REF

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24894-C52 SCREW
(1 PER SIDE)

AN3C5A BOLT
NAS1149C0332R WASHER
36 PL

PLUG INSERTS WITH
AN3C5A BOLT
NAS1149C0332R WASHER
6 PL

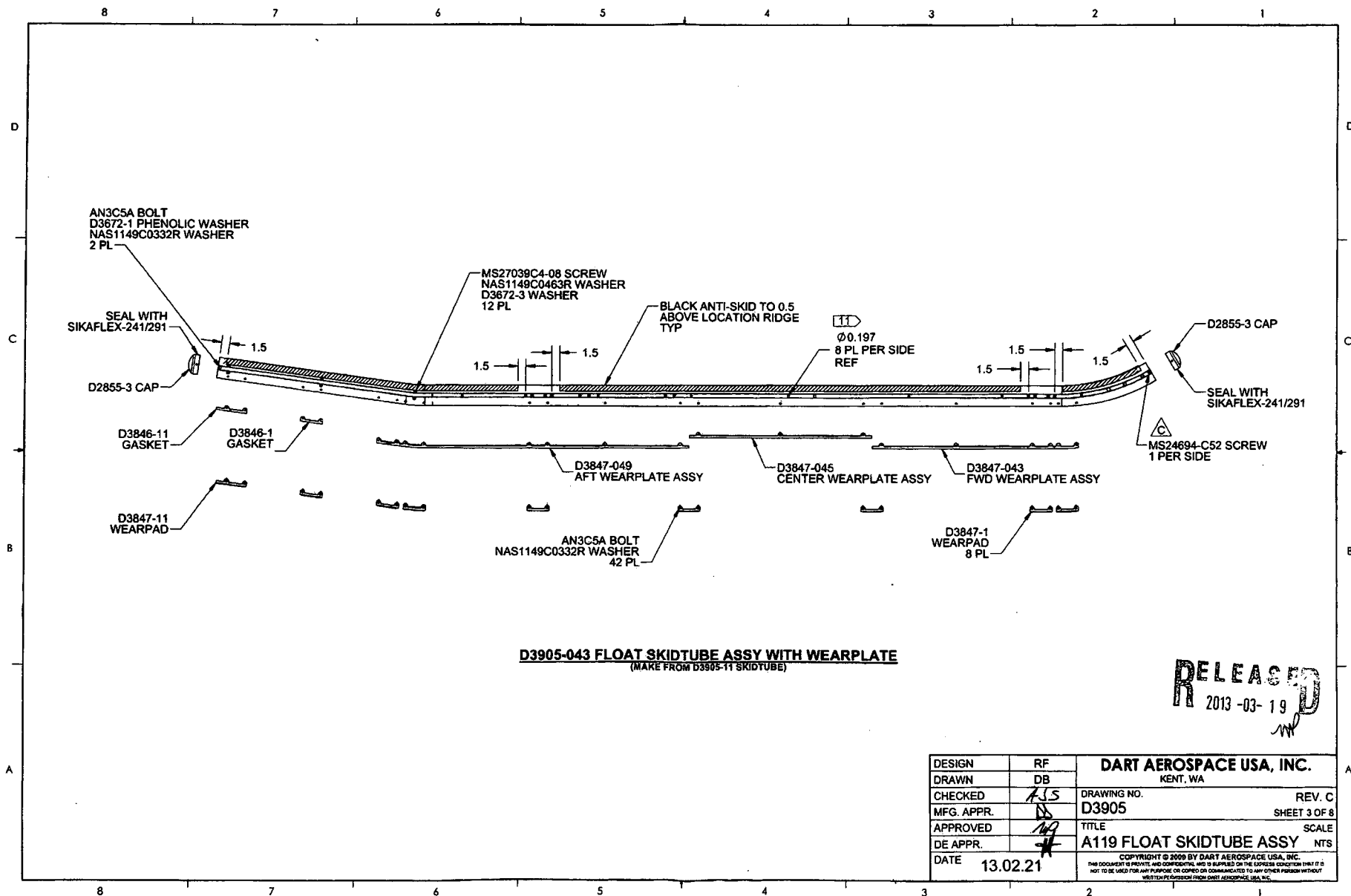
D3846-1
GASKET
8 PL

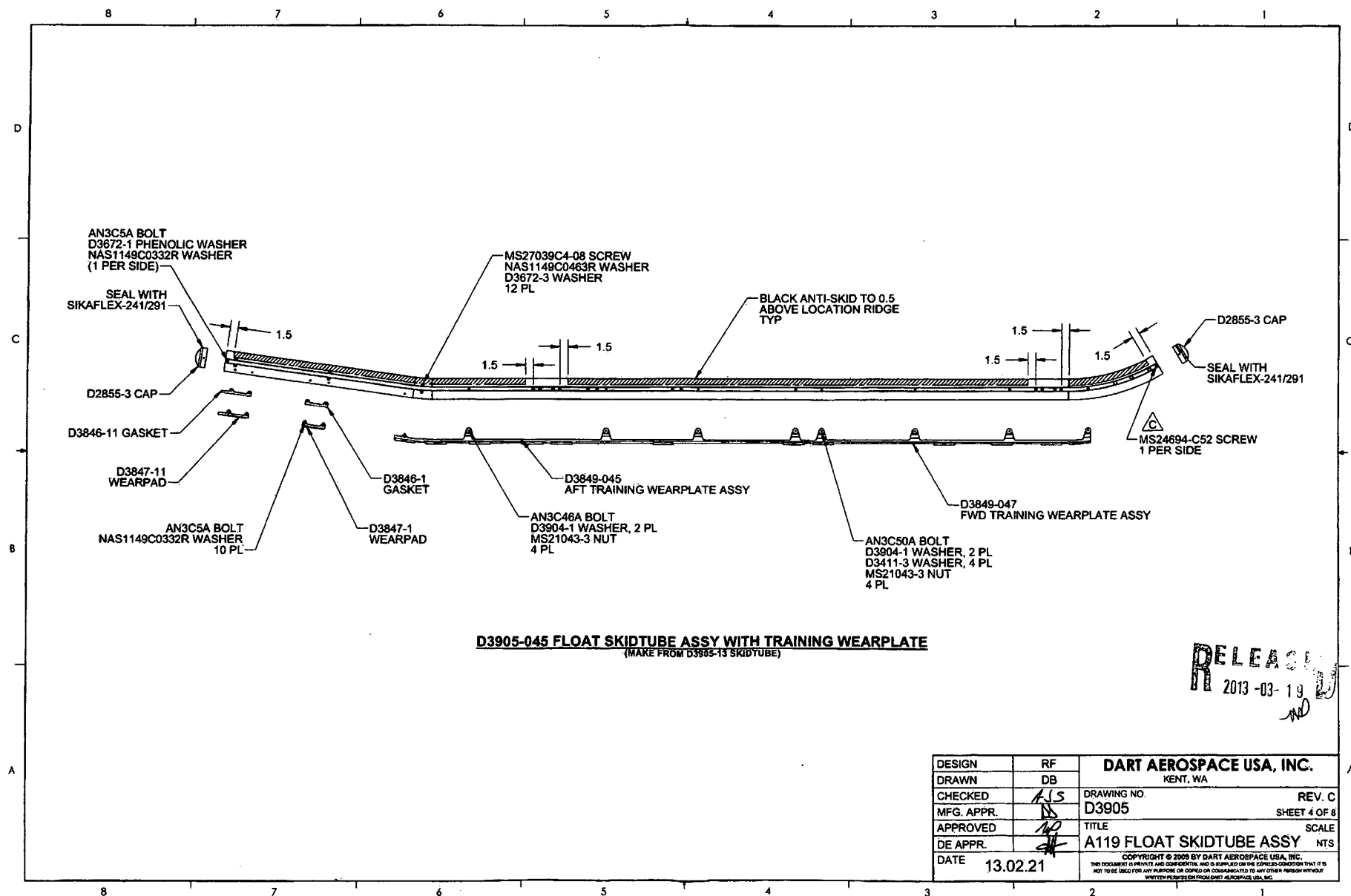
D3847-1
WEARPAD
8 PL

D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3905-11 SKIDTUBE)

RELEASE
R 2013-03-19
JW

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MFG. APPR.	DB	D3905	SHEET 2 OF 8
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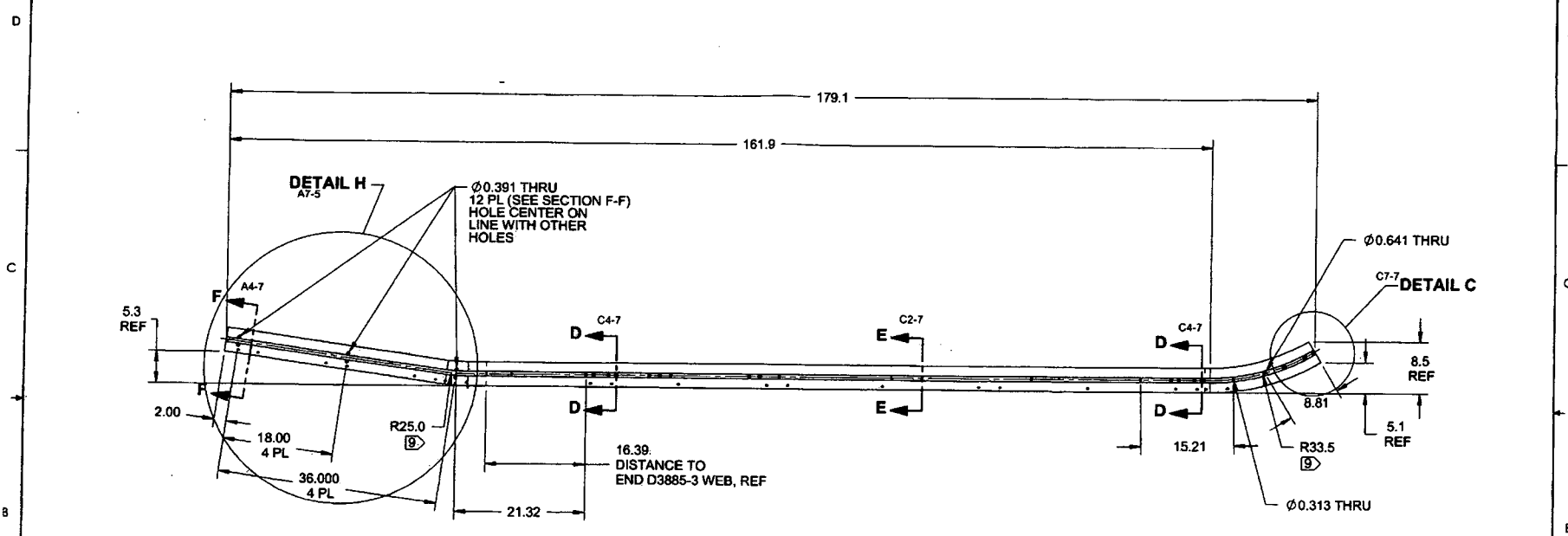




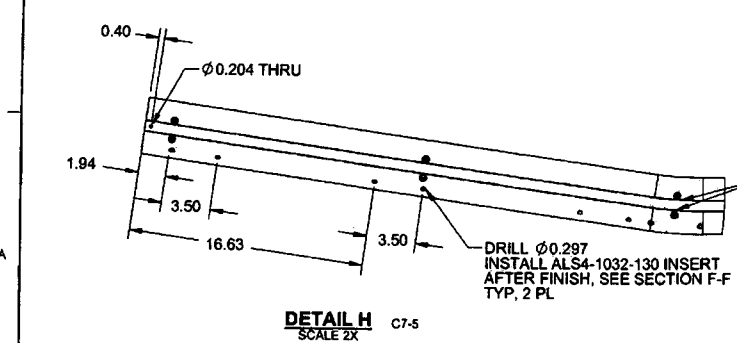
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8 7 6 5 4 3 2 1



D3905-11 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

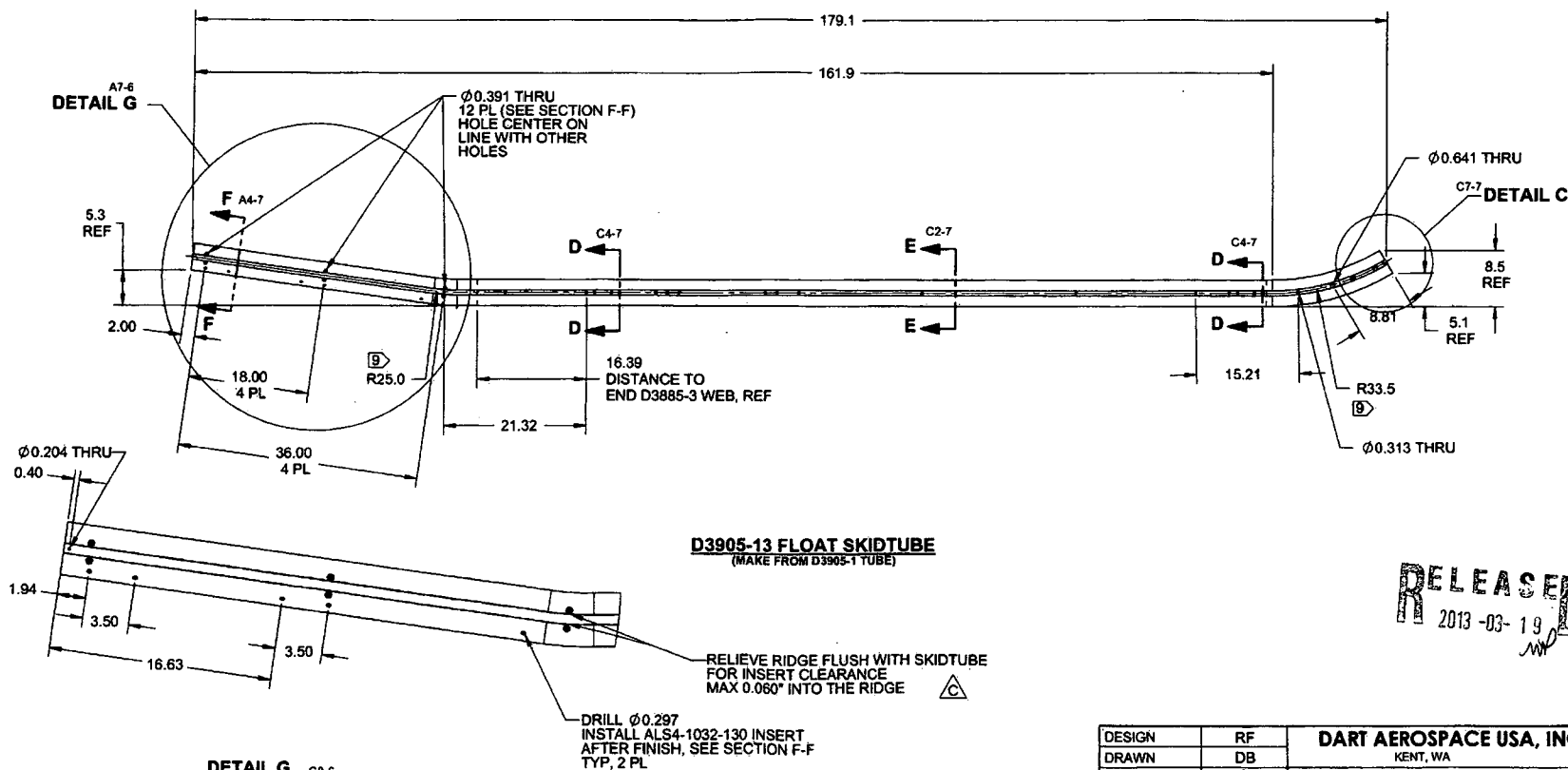


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2013-03-19

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MFG. APPR.	DS	D3905	SHEET 5 OF 8
APPROVED	AD	TITLE	SCALE
DE APPR.	JS	A119 FLOAT SKIDTUBE ASSY	NTS
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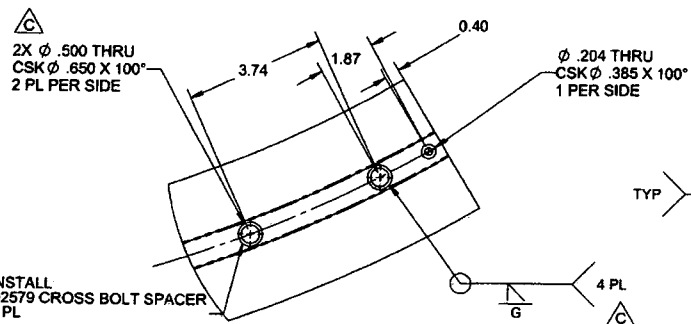
DETAIL G



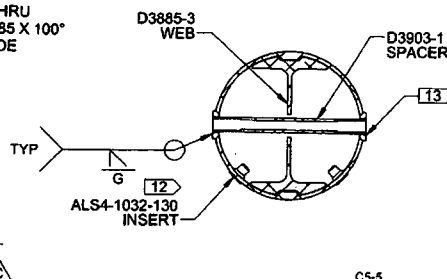
D3905-13 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

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2013-03-19

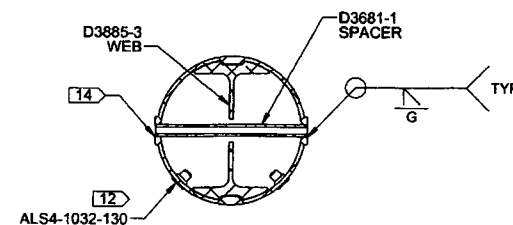
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CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3905	SHEET 6 OF 8
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	A119 FLOAT SKIDTUBE ASSY	NTS
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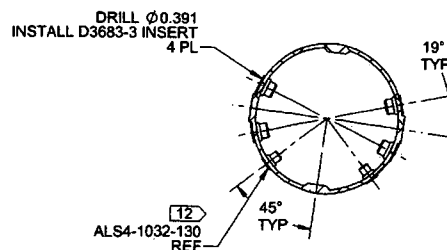
DETAIL C
SCALE 4X
C1-5
C1-6



SECTION D-D
SCALE 4X
C5-5
C2-5
C5-6
C2-6
(FOR 12 x Ø 0.375 HOLES
PER SKIDTUBE)



SECTION E-E
SCALE 4X
C4-5
C4-6
(FOR 8 x Ø 0.313 HOLES
PER SKIDTUBE)



SECTION F-F
SCALE 4X
C7-8
C7-5

NOTES:

13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø 0.375 HOLES ONLY:

- CHAMFER HOLES Ø 0.475 x 45° (BOTH SIDES)
- INSERT D3903-1 SPACER
- WELD INTO PLACE AND GRIND FLUSH
- C BORE TO 0.313 x 0.75 DEEP
- DEBURR HOLES

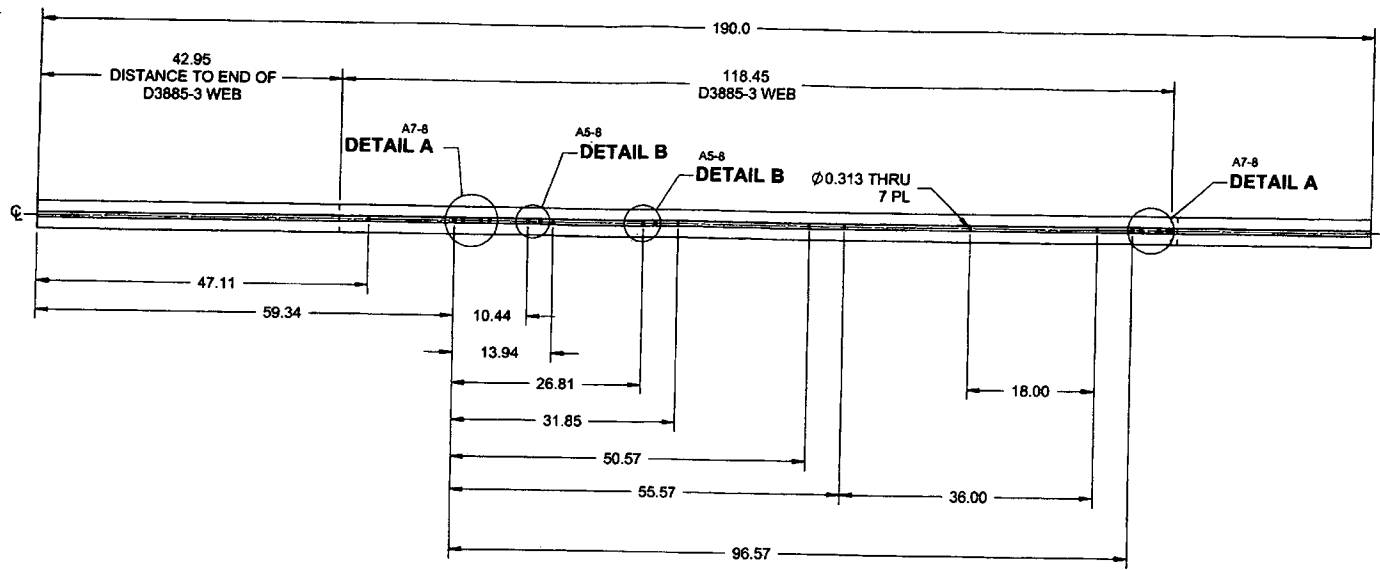
14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø 0.313 HOLES ONLY:

- CHAMFER HOLES Ø 0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
- INSERT D3681-1 SPACER
- WELD INTO PLACE AND GRIND FLUSH
- DEBURR HOLES

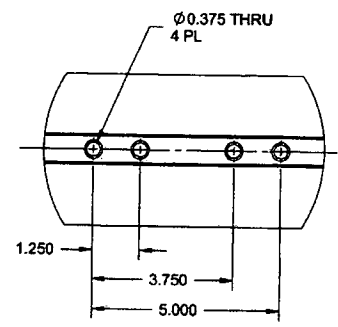
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2013-03-19

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CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DS	D3905	SHEET 7 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	CH	A119 FLOAT SKIDTUBE ASSY	NTS
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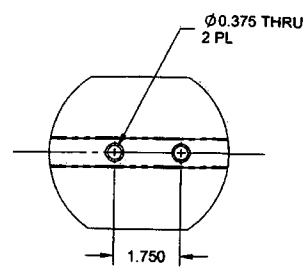
8 7 6 5 4 3 2 1



D3905-1 TUBE
 (MAKE FROM D2500-1-190 EXTRUSION)



DETAIL A
 SCALE 4X
 D6-8
 D2-8



DETAIL B
 SCALE 4X
 D5-8
 D4-8

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 2013-03-19
 MO

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DRAWN	DB	KENT, WA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D3905	SHEET 8 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	A119 FLOAT SKIDTUBE ASSY	NTS
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